



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3319-1

Job Sheet 169848



Part No: D3319-1

Job Qty: 12 ea

Part Name: Forward Wearplate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/31/17

Job Tracking No:

Due Date: 1/9/18

Created By: Linda Lacelle

Type: SOLD

Description:

Customer: Heliswiss Iberica SA (CHELI02)

Hangar 4, Lado Norte, Aeropuerto De Sabadell, Barcelona Sabadell, , 08205 Spain ph:011 34 93 720 6090
fx:34-937-100130.

Note: IPP: B 05.10.14 Added step 9, dwg rev B KJ/EC IPP Rev:C Now on Waterjet 06-10-26 JLM IPP REV:D
17.10.25 AS PER DWG REV:D DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	1/8/18	1/8/18	0.00	0.00	Start Up Waterjet		18/01/02 SC
100	Waterjet	12 pcs	1/8/18	1/8/18	0.00	1.25	Waterjet1		18/01/02 SC
110	QC	12 pcs	1/8/18	1/8/18	0.00	0.00	QC2 Waterjet-2		18/01/02 SC
120	QC	12 pcs	1/8/18	1/8/18	0.00	0.00	QC8-2		38
140	Brake NC	12 pcs	1/8/18	1/8/18	0.07	0.87	Brake NC 1		38
150	QC	12 pcs	1/8/18	1/8/18	0.00	0.00	QC5		38
160	Autoweld 1	12 pcs	1/8/18	1/8/18	0.00	3.08	Automated welding		38 DAS
170	QC	12 pcs	1/8/18	1/8/18	0.00	0.00	QC10		38 DAS
180	QC	12 pcs	1/8/18	1/8/18	0.00	0.00	QC5		38 9-88
190	SprayPaint	12 pcs	1/9/18	1/9/18	0.00	0.28	Spray Paint		✓ AS 28 28 2018
200	QC	12 pcs	1/9/18	1/9/18	0.00	0.00	QC3		38 31 2018
210	Packaging	12 pcs	1/9/18	1/9/18	0.00	0.00	Packaging3-1		5603 31 2018
220	QC21-SA	12 Ea	1/9/18	1/9/18	0.00	0.00	QC21		38 31 2018

Part Op 100 - 1-Cut as per Dwg D3319 Dwg Rev: D Prog Rev: D 2-Deburr if necessary

Descriptions: 140 - 1- Form using DT8326 & DT8261 as per Dwg D3319Rev: 2 2- Form flat on press using DT8776 block

160 - 8259 HARDCOAT B: 5024335

190 - COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURE COATING AS PER DWG NOTE 9 SHEET ONE.
BATCH: 138714

210 - Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd.
P/N: D3319-1, B/N: BXXXXX For Product Eligibility see PDA05-18 and Stock Location: _____

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304S18GA	8	136	0	0

M137481 875
M136790 1.3
M138486 3.16
5007416 2.84

DART
AEROSPACE
S027874



Forward Wearplate

PART NO: D3319 - 1
Revision:
Operation: Start up Operation
Change No:

Mfg Date: 01/02/18 Job No: 169848
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Dart Aerospace Ltd.

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Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate	4.980inches $\pm$ 0.030	5.010 4.950	4,978	
2	Wearplate	1.600inches $\pm$ 0.010	1.610 1.590	1,6	
3	Wearplate	2.660inches $\pm$ 0.010	2.670 2.650	2,662	
4	Wearplate	3.190inches $\pm$ 0.010	3.200 3.180	3,192	
5	Wearplate	3.563inches $\pm$ 0.010	3.573 3.553	3,561	
6	Wearplate	4.710inches $\pm$ 0.030	4.740 4.680	4,720	
7	Wearplate	0.600inches $\pm$ 0.030	0.630 0.570	0,6	
8	Wearplate	10.576inches $\pm$ 0.010	10.586 10.566	10,578	
9	Wearplate	11.942inches $\pm$ 0.010	11.952 11.932	11,943	
10	Wearplate	18.090inches $\pm$ 0.030	18.120 18.060	18,07	
11	Wearplate	0.316inches + 0.006 - 0.001	0.322 0.315	0,317	
12	Wearplate	0.546inches $\pm$ 0.010	0.556 0.536	0,545	
13	Wearplate	0.316inches + 0.006 - 0.001	0.322 0.315	0,317	
14	Wearplate	0.670inches $\pm$ 0.010	0.680 0.660	0,671	
15	Wearplate	0.190inches + 0.005 - 0.001	0.195 0.189	0,191	
16	Wearplate	3.815inches $\pm$ 0.010	3.825 3.805	3,816	
17	Wearplate	16.100inches $\pm$ 0.010	16.110 16.090	16,101	

Plex 12/31/17 11:26 AM dart.lacelle.linda